

Work Order ID 123051

Tuesday, July 29, 2014 2:29:23 PM

\*123051\*

Page 1

Job ID: D3589-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Latch Assembly

Stop

\*NS2\*

Start Date: 7/29/14 Start Qty: 2.00

\*P\*  
\*D\* 3

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: J.A

Date: 14/07/130 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3589 C

100

0.00

3

14-09-22

JBL

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

\*\*\* ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS\*\*\*

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004  
\*\*\*ensure parts fit correctly on jig\*\*\*

A/R Stainless Steel Rod Batch: 125054

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Quality Control

Memo 0.00

3 SEP 29 2014

DAS

24

989

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____	Suspected Unapproved <input type="checkbox"/>			Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General								
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Crushing P R 430 <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Work Order ID 123051

Tuesday, July 29, 2014 2:29:23 PM

\*123051\*

Page 2

Item ID: D3589-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Latch Assembly

Stop

\*NS2\*

Start Date: 7/29/14 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				3	SEP 29 2014		DAS 24 9-89

Quality Control

130

**\*130\***

Small Fab

Memo

0.00

3 FF 14-09-30

Small Fab

1- Assemble as per dwg

140

**\*140\***

QC

Memo

0.00

DAS

38

9-89

14-9-30

Quality Control

(3)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: \_\_\_\_\_

Work Order update only 

Work Order: _____  Part No. _____  NCR No. _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
				Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
		Suspected Unapproved	Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre.	WES 03 532								
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General														
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced										
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up										
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure										
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld										
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled										
	Crushing	Countersink	Misaligned/off center	Positioned Wrong											
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other										
	Inspection Strip in Tube	Drawing	Misread												
	Marks/Chatter	Drill Holes	Off-set												
	Turning Sequence	Finish	Out of Calibration												
	Wave/Twist in Tube	Fit/Function	Out of Sequence												

**Work Order ID 123051**

Tuesday, July 29, 2014 2:29:23 PM

**\*123051\***

Page 3

Item ID:	D3589-041	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>		
Revision ID:				Stop		<b>*NS2*</b>		
Item Name:	Latch Assembly							
Start Date:	7/29/14	Start Qty:	2.00	<b>*2*</b>	Cust Item ID:			
Required Date:	7/29/14	Req'd Qty:	2.00	<b>*2*</b>	Customer:			
Reference:						Run	Start	<b>*NR1*</b>
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop	<b>*NR2*</b>	
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST231</u>	0.00							<u>DAS</u> <u>28</u> <u>9.89</u>

**\*150\***

Packaging

Packaging

160	QC21- Final Inspection - Work Order Release	0.00	<u>MW</u> <u>14-10-01</u>
<b>*160*</b>	Memo	0.00	<u>ADM-10.01</u>
QC			
Quality Control			

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

## Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
NCR No. _____				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Prep	97%										
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending			Bend		Folio/Program		Outside Dimensions		Pressure/Forced		
Centre Not Concentric			BOM/Route		Grain		Over/Under tolerance		Set-up		
Cracks			Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure		
Crimp/Kink/Ripple/Wave			Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld		
Cuffs			Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
Crushing			Countersink		Misaligned/off center		Positioned Wrong				
Heat Treat			Cut Too Short		Mislabeled		Power Loss/Surge				
Inspection Strip in Tube			Drawing		Misread						
Marks/Chatter			Drill Holes		Off-set						
Turning Sequence			Finish		Out of Calibration						
Wave/Twist in Tube			Fit/Function		Out of Sequence						

**Picklist Print**

Page 1

Tuesday, July 29, 2014 2:29:22 PM

Work Order ID: 123051

**\*123051\***  
**\*D3589-041\***

Parent Item: D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 2.00

Required Qty: 2.00

**Comments:** IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise process as per coss DD 10.01.18 verified by:EC IPP REV:C 12.07.23 AS PER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3589-1		Manufactured	No		100	Each	4.0000		1	2			
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**\*D3589-1\***

Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	4	
	4	
	113215	

D3589-11

**\*D3589-11\***

Fwd Guide Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	4	
	4	
	113568	

D3589-13

**\*D3589-13\***

Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	17	
	13	
	4	
	113171	
	113766	

D3589-15

**\*D3589-15\***

Link

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	10	
	10	
	113162	

14-09-18  
JBL14-09-18  
JBL14-09-18  
JBL

FF 14-09-30

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____		Use-as-is <input type="checkbox"/>	Suspected Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	Bending <input type="checkbox"/>	General <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>				
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>				
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>				
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>						
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>						
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						

# Picklist Print

Page 2

Tuesday, July 29, 2014 2:29:22 PM

Work Order ID: 123051

**\*123051\***  
**\*D3589-041\***

Parent Item: D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 2.00

Required Qty: 2.00

D3589-23

Manufactured No

100

Each

37.0000

2

4

\*\*

**\*D3589-23\***

Arm Guide

14-09-18

JBL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST056	35	
WA002	35	
105462	2	
	2	

163
_____
_____

D3589-3

Manufactured No

130

Each

15.0000

2

4

\*\*

**\*D3589-3\***

Arm Guide

14-09-18

JBL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	15	
110528	15	

161
_____

D3589-7

Manufactured No

100

Each

4.0000

1

2

\*\*

**\*D3589-7\***

Aft Guide Plate

14-09-18

JBL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	4	
110926	4	

131
_____

D3589-9

Manufactured No

100

Each

1.0000

1

2

\*\*

**\*D3589-9\***

Fwd Guide Plate

14-09-18

JBL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	1	
113089	1	

131
_____

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric	Bend	Grain	Over/Under tolerance	Set-up
	Cracks	BOM/Route	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs	Burrs	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing	Contamination	Misaligned/off center	Positioned Wrong	
	Heat Treat	Countersink	Mislabeled	Power Loss/Surge	
	Inspection Strip in Tube	Cut Too Short	Misread		
	Marks/Chatter	Drawing	Off-set		
	Turning Sequence	Drill Holes	Out of Calibration		
	Wave/Twist in Tube	Finish	Out of Sequence		
		Fit/Function			

# Picklist Print

Page 3

Tuesday, July 29, 2014 2:29:22 PM

Work Order ID: 123051

**\*123051\***  
**\*D3589-041\***

Parent Item: D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 2.00

Required Qty: 2.00

MS20392-1C7

Purchased No

130 Each 52.0000 2 4

\*\*

**\*MS20392-1C7\***

Pin

FF 14-09-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST314	52	
m125807	10	
m127304	2	
m128976	40	

MS24665-1010

Purchased No

130 Each 236.0000 2 4

\*\*

**\*MS24665-1010\***

COTTER PIN

FF 14-09-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	236	
108335	200	
114405	36	

NAS1149DN432J

Purchased No

130 Each 332.0000 4 8

\*\*

**\*NAS1149DN432J\***

WASHER

FF 14-09-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CA	138	
m129682	138	
ST277	194	
m127832	100	
<u>m129022</u>	94	12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

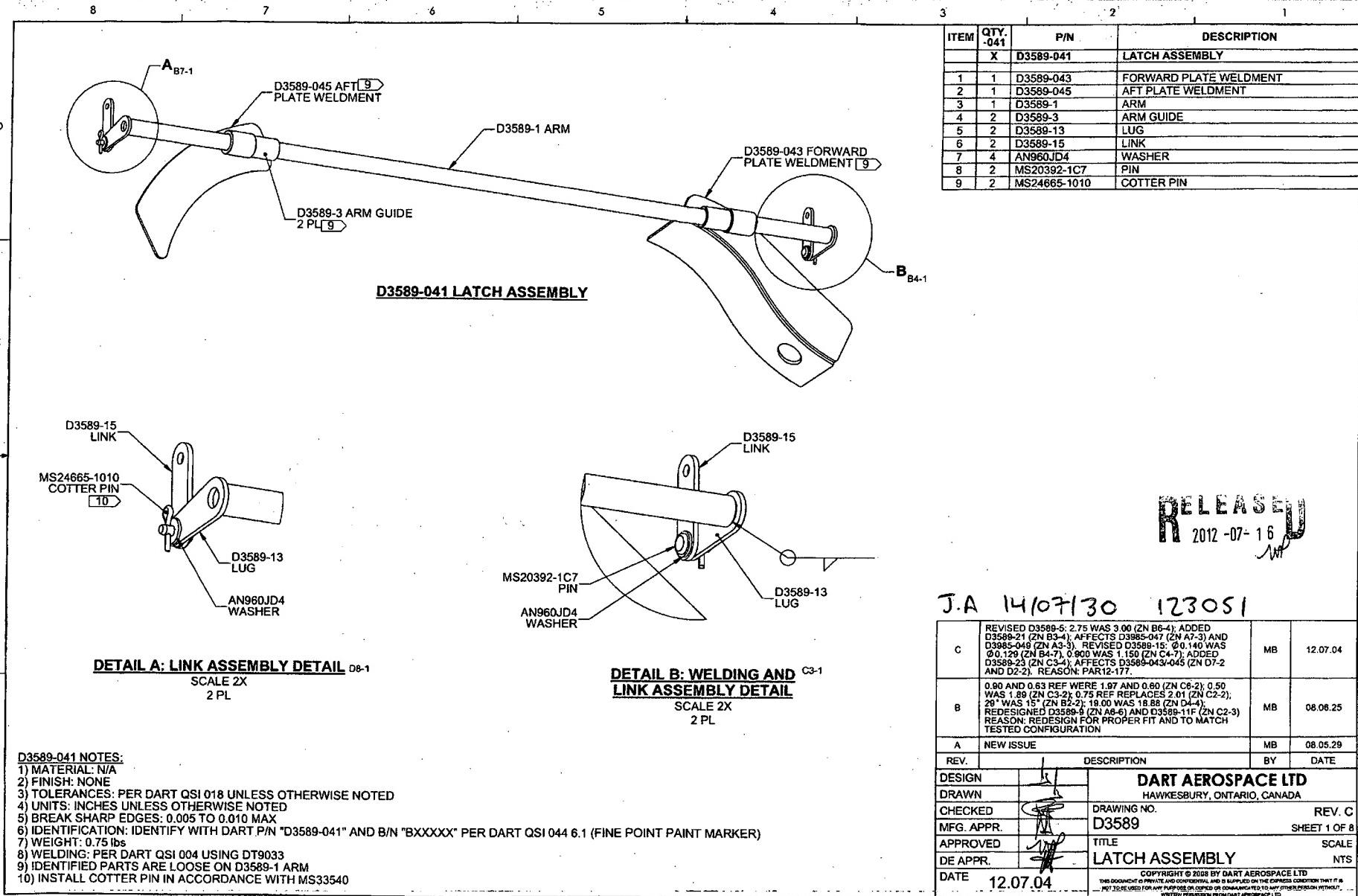
Work Order update only 

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

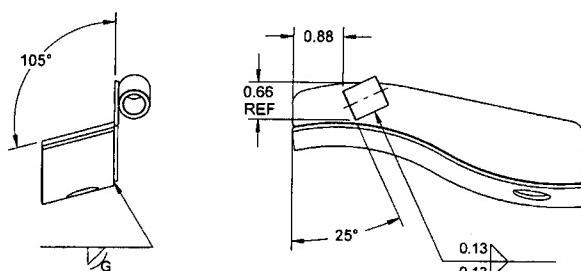
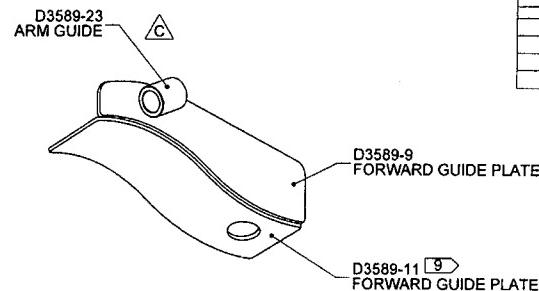
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

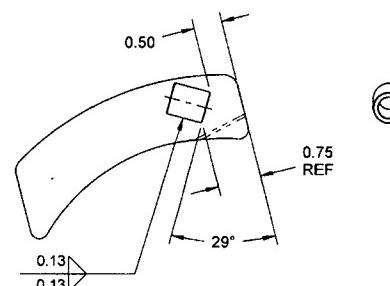
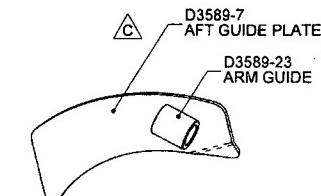
Landing Gear	Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/>	General	Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>
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ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X	X	D3589-043	FORWARD PLATE WELDMENT
			D3589-045	AFT PLATE WELDMENT
1	1	1	D3589-7	AFT GUIDE PLATE
2	1		D3589-9	FORWARD GUIDE PLATE
3	1		D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



D3589-043 FORWARD PLATE WELDMENT



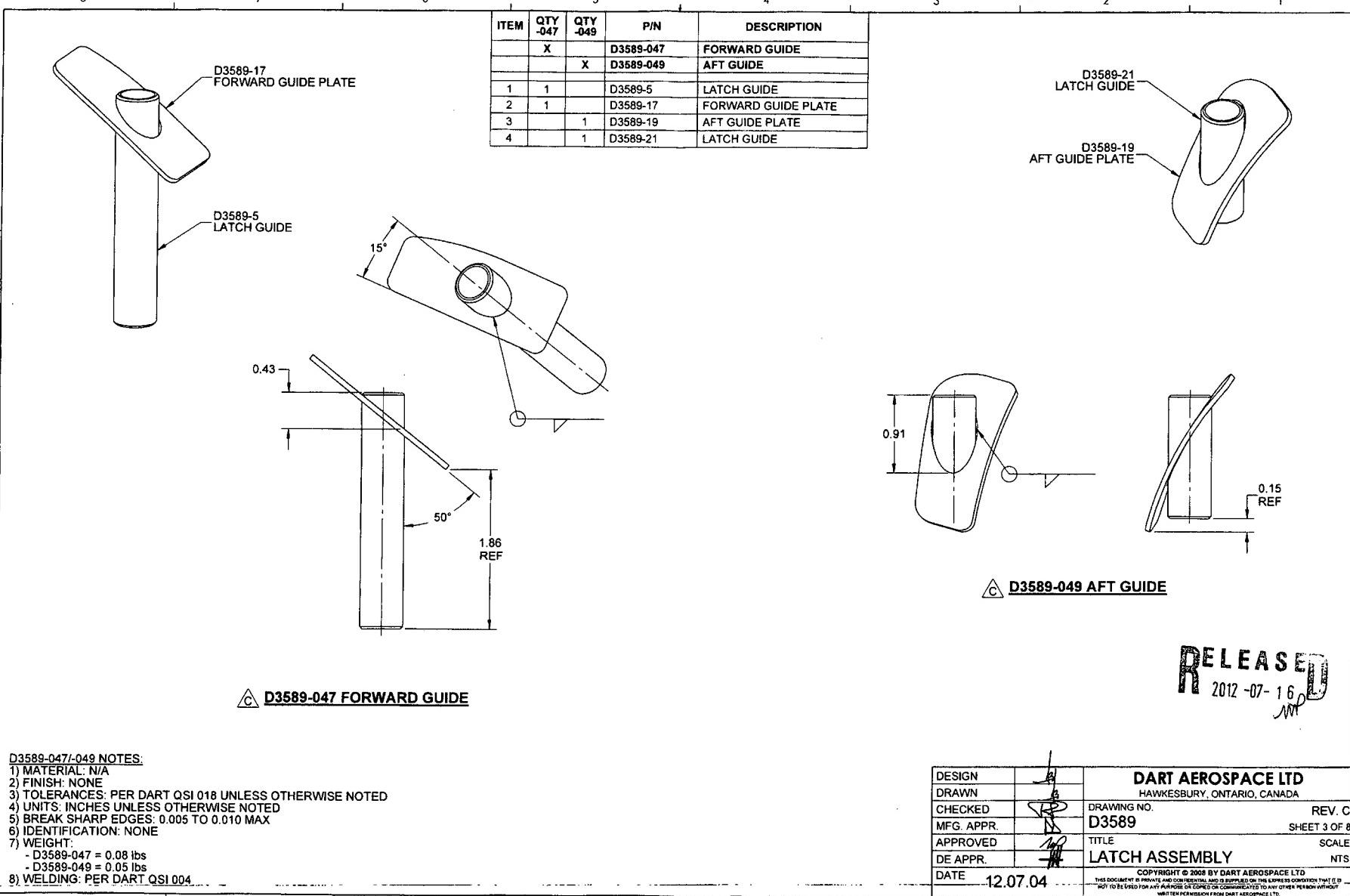
D3589-045 AFT PLATE WELDMENT

D3589-043/045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
  - D3589-043 = 0.23 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

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CHECKED	<i>RP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>NA</i>	D3589	SHEET 2 OF 8
APPROVED	<i>RP</i>	TITLE	SCALE
DE APPR.	<i>RP</i>	LATCH ASSEMBLY	NTS
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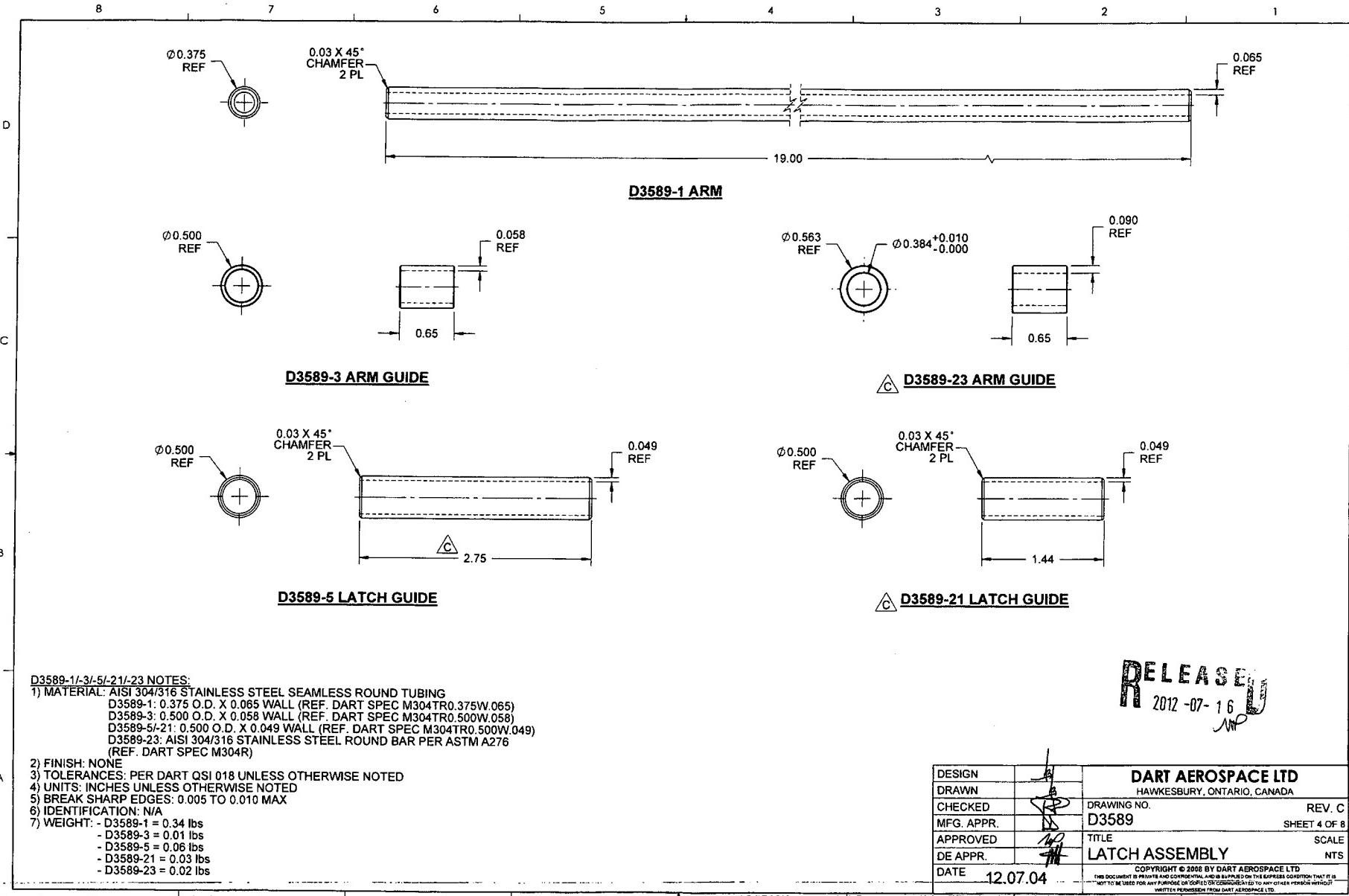
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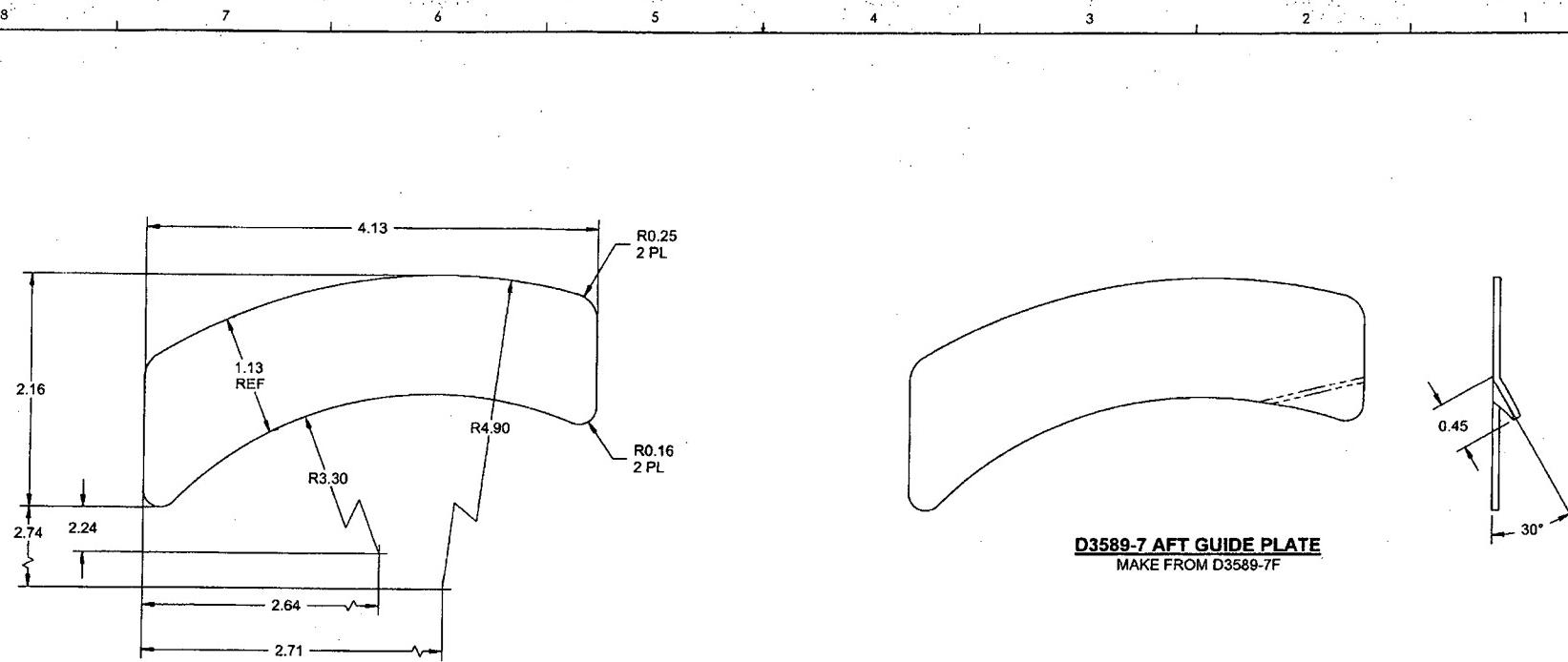


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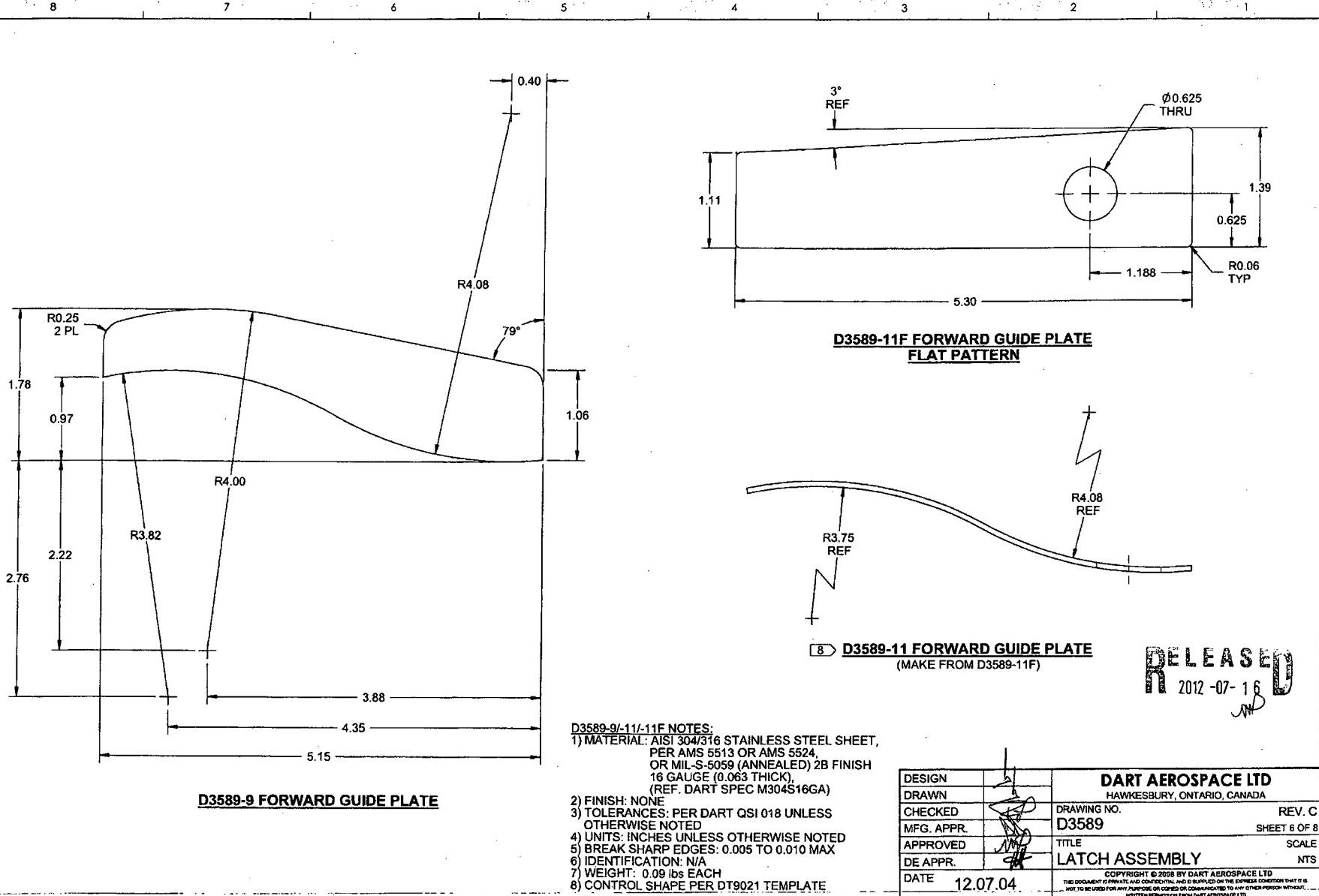


**D3589-7 AFT GUIDE PLATE**  
MAKE FROM D3589-7F

RELEASED  
2012-07-16  
*[Handwritten signature]*

- A. D3589-7/-7F NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.09 lbs

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MFG. APPR.	<i>[Signature]</i>	D3589 SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE SCALE
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DESIGN	<i>b</i>	DART AEROSPACE LTD	
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CHECKED	<i>✓</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>✓</i>	D3589	SHEET 6 OF 8
APPROVED	<i>N/A</i>	TITLE	SCALE
DE APPR.	<i>N/A</i>	LATCH ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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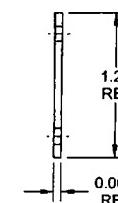
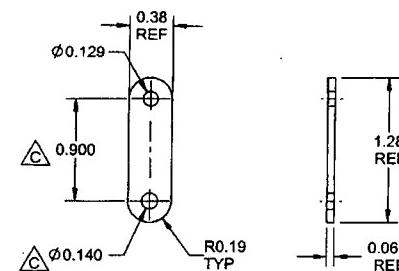
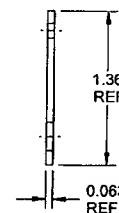
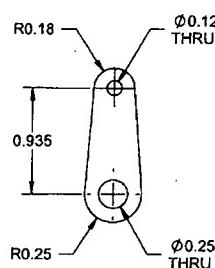
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B

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A

A



- D3589-13-15 NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK). (REF. DART SPEC M304S16GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs EACH

8 7 6 5 4 3 2 1

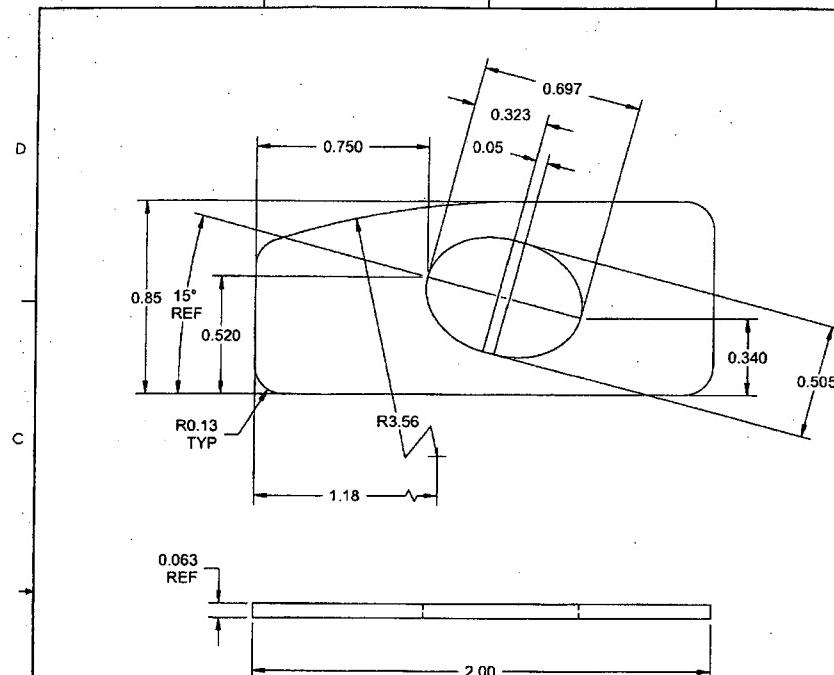
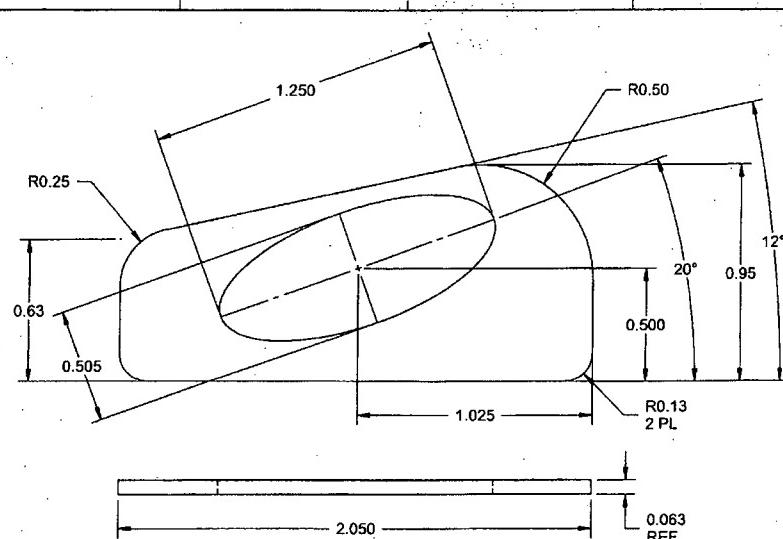
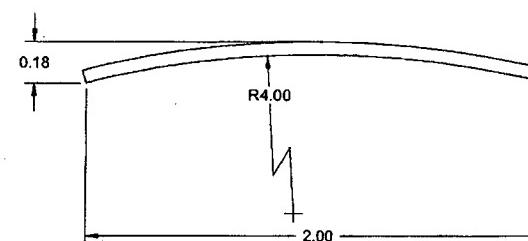
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		LATCH ASSEMBLY

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

**D3589-17 FORWARD GUIDE PLATE****D3589-19F AFT GUIDE PLATE FLAT PATTERN****D3589-19 AFT GUIDE PLATE  
(MAKE FROM D3589-19F)**

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- A  
D3589-17/-19/-19F NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.02 lbs EACH

8 7 6 5 4 3 2 1

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MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3589
APPROVED	<i>[Signature]</i>	SHEET 8 OF 8
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8 7 6 5 4 3 2 1